

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
22 March 2001 (22.03.2001)

PCT

(10) International Publication Number
WO 01/20121 A1

(51) International Patent Classification⁷: **E21B 21/00,**
21/06

(74) Agents: RIDDLE, J., Albert et al.; Baker Hughes Incorporated, 3900 Essex Lane, Suite 1200, Houston, TX 77027 (US).

(21) International Application Number: PCT/US00/25252

(22) International Filing Date:
14 September 2000 (14.09.2000)

(81) Designated States (*national*): GB, NO.

(25) Filing Language: English

(84) Designated States (*regional*): European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE).

(26) Publication Language: English

(30) Priority Data:
60/153,771 14 September 1999 (14.09.1999) US

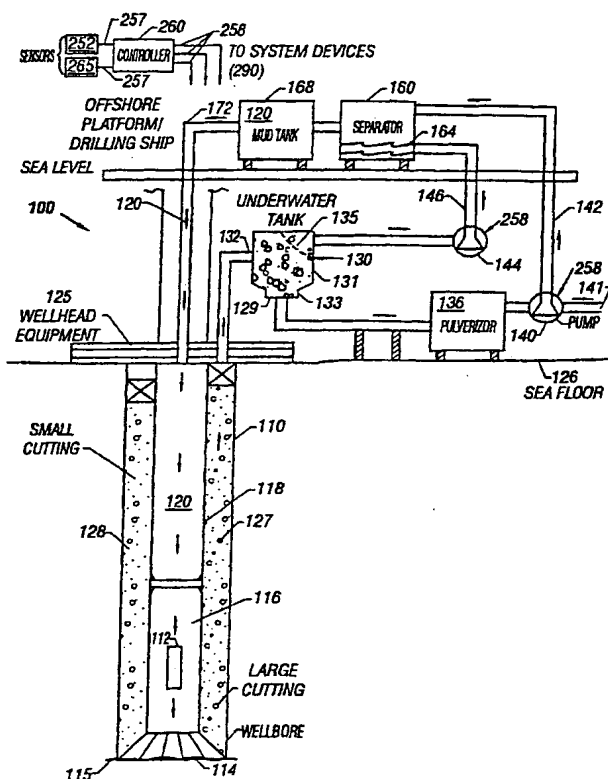
Published:
— With international search report.

(71) Applicant: DEEP VISION LLC [US/US]; 10th floor, 4 Greenway Plaza, Houston, TX 77046 (US).

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

(72) Inventors: FINCHER, Roger, W.; 23B Amherst Court, Conroe, TX 77304 (US). FONTANA, Peter; 3918 Byron, Houston, TX 77005 (US).

(54) Title: APPARATUS AND METHOD FOR THE DISPOSAL OF DRILLING SOLIDS DURING DRILLING OF SUBSEA OILFIELD WELLBORES



(57) Abstract: The system may include a separator (130) at the sea floor adjacent the wellhead, which separates solids above a predetermined size from the wellstream. The wellstream then enters one or more underwater pumps (144), which pump the wellstream to the surface. A crusher (136), as a separate unit, integrated in the separator or in the pump, receives the separated solids and reduces them to relatively small-sized particles. The small particles are then pumped or moved to the surface by the pumps utilized for pumping the wellstream to the surface or by a separate underwater pump. Alternatively, the separated solids are collected from the separator into a container, which container is then transported to the surface by a suitable method. Solids reaching the surface are removed to obtain filtered fluid, which after conditioning by conventional methods is pumped back into the wellbore as the drilling fluid.

WO 01/20121 A1

THIS PAGE BLANK (USPTO)

APPARATUS AND METHOD FOR THE DISPOSAL OF DRILLING SOLIDS DURING DRILLING OF
SUBSEA OILFIELD WELLBORES

5

BACKGROUND OF THE INVENTION**1. Field of the Invention**

This invention relates generally to drilling of oilfield wellbores and more particularly to apparatus and method for processing (separation, resizing and/or disposition) at the sea floor at least a portion of solids returning with the drilling fluid to the sea floor wellhead during drilling of subsea wellbores.

2. Description of Related Art

Oilfield wellbores or boreholes are drilled by rotating a drill bit attached to the bottom of a drill string. The drill bit is rotated by rotating the entire drill string from the surface and/or by a drilling motor (also referred to in the oil and gas industry as the "mud motor") disposed in a bottomhole assembly attached to the drill bit. In either case, a drilling fluid, which is usually a mixture of water or oil and various additives (commonly referred to as the "mud") is supplied under pressure from a source thereof at the surface into the drill string tubing, which may be a jointed pipe or coiled tubing.

In drilling subsea wellbores, the drilling fluid passes through the tubing, bottomhole assembly and drilling motor (when used) and discharges at the drill bit bottom. The drilling fluid discharging at the wellbore bottom and then returning to the wellhead at the sea floor via the annular space (the "annulus") between the drill string and the wellbore wall. The rock disintegrated by the drill bit rotation (commonly referred to as the "cuttings" or the "drill cuttings") is carried to the subsea wellhead by the returning drilling fluid via the annulus. Additionally, solids may enter into the returning drilling fluid due to caving of the rock along the drilled wellbore. Solids may also be present in the form of metal cuttings due to cutting of holes in metallic pipes to form junctions for drilling lateral wellbores or in the form of chunks of cement dislodged from completed or partially completed sections of the wellbore. The returning drilling fluid carrying the above-described solids is sometimes referred to herein as the return fluid or "wellstream."

During drilling of certain types of subsea wellbores, such as dual gradient type, solids in the fluid returning to the wellhead at the sea floor must be properly managed. In certain subsea applications, the return fluid is pumped to the surface by pumps at the sea floor. These pumps can allow passage of solids of up to a certain size and hardness without being damaged. The solids, however, can vary greatly in size and

hardness, with some solids being greater in size than the pump specifications. Unless the oversized solids are first removed or resized, they can plug or damage the pumps. Replacing pumps in deep sea drilling operations can be very expensive.

5 Thus, the subsea pumps must be protected from plugging or damage caused by the impact of the drilling fluid solids on the internal parts of the pumps. Particle impact, depending upon the size, hardness, and density of the solids, can gradually erode the pumps, cause catastrophic failures, or plug the pumps.

10

The present invention addresses the above-noted problems and provides apparatus and methods for processing the return fluid including separating solids, resizing solids and transporting the fluid to the surface without plugging or damaging the subsea pumps.

15

SUMMARY OF THE INVENTION

The present invention provides apparatus and methods for processing of drilling fluid returning to the wellhead in subsea drilling operations. In one aspect, the invention provides apparatus and
20 methods for controlling the particle size of the solid mass present in the circulating drilling fluid returning to the subsea wellhead during drilling of a subsea wellbore. The system includes a separator at the sea floor

adjacent the wellhead, which separates solids above a predetermined size from the return fluid. The subsea separator may be a mechanical separator, a hydrocyclone-type separator or any other type of separator judged suitable for the task. The return fluid from the separator enters
5 into one or more subsea pumps, which pump the fluid to the surface. A crusher or pulverizer, either integrated in the separator or as a separate unit, receives the separated solids and reduces them to relatively small-sized particles. The small particles are then pumped to the surface by subsea pump(s) which may be the same pumps utilized for pumping the
10 return fluid to the surface or separate subsea pumps. Alternatively, the separated solids may be collected from the separator into a container. The container is then transported to the surface by a suitable method. Alternatively, filtered drilling fluid may be used to lift the collected solids to the surface. In an alternative system, the return fluid may be passed
15 directly to a crusher that reduces the particle size of the larger solids. The fluid and the small solids are then pumped to the surface. The crusher and the pump may be integrated into a common unit or may be separate serially arranged units. Solids in the wellstream reaching the surface are filtered or removed by conventional methods. The filtered
20 fluid is conditioned to obtain the desired drilling fluid properties. This conditioned fluid is pumped back into the wellbore as the drilling fluid.

Examples of the more important features of the invention thus have been summarized rather broadly in order that the detailed description thereof that follows may be better understood, and in order that the contributions to the art may be appreciated. There are, of course, additional features of the invention that will be described hereinafter and which will form the subject of the claims appended hereto.

BRIEF DESCRIPTION OF THE DRAWINGS

10 For detailed understanding of the present invention, reference should be made to the following detailed description of the preferred embodiments taken in conjunction with the accompanying drawings, in which like elements have been given like numerals, and wherein:

15 **Figure 1** is a schematic diagram of a system for the processing and disposition of solids received at the wellhead with the circulating drilling fluid during drilling of a subsea wellbore according to one aspect of the present invention;

20 **Figure 2** is a schematic diagram of an underwater separator with a pulverizer for reducing the size of solids contained in the drilling fluid returning to the underwater wellhead;

Figure 3 is a schematic diagram of a system wherein a common subsea pump is utilized to pump to the surface the filtered drilling fluid from the underwater separator and also for transporting pulverized or crushed solids;

5

Figure 4 is a schematic diagram of a system at the sea floor wherein large solids separated from the wellstream by a separator are collected in a container that can be transported to the surface;

10

Figure 5 is a schematic diagram of a system wherein an underwater separator separates solid mass from the wellstream and a common pump transports the filtered drilling fluid and the separated solids to the surface;

15

Figure 6 is a schematic diagram of a system wherein a crusher reduces the size of solids and a serially coupled pump system pumps the drilling fluid and the reduced solids to the surface; and

20

Figure 7 is a schematic diagram of a system wherein the crusher and pump system form an integral unit.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

Figure 1 shows a schematic diagram of a system **100** for controlling the particle size of solids in the circulating drilling fluid received at the wellhead on the sea floor during drilling of a subsea wellbore according to one embodiment of the present invention. **Figure 1** shows a wellbore **110** being drilled by rotating a drill bit **114** attached to the bottom of a drilling assembly or bottomhole assembly **116**, which is attached to the bottom end of a tubing **118** conveyed from a rig or workstation **162** at the surface. To drill the wellbore **110**, the drill bit **114** is rotated by rotating the tubing **118** (if jointed pipes are used to make up the tubing) and/or by a mud motor **112** disposed in the drilling assembly **116**. The rotating drill bit **114** disintegrates the rock and produces rock debris **127** (commonly referred to as the "drill cuttings" or the "cuttings") of various sizes. A drilling fluid **120** is pumped or supplied under pressure to the tubing **118** from a mud pit or tank **168** via a line **172**. The drilling fluid **120** discharges at the drill bit bottom **115** and returns to the wellhead **125** via the annulus **128**. The drilling fluid **120** carries solids **127**, such as the drill cuttings, rocks entering the wellstream due to the caving of wellbore sections, and metal pieces left in the wellbore due to the cutting of drill pipe or metals in the wellbore, for example, remaining from construction of lateral wellbores, and loose cement chunks left in the wellbore during cementing of portions of the wellbore **110**.

Still referring to **Figure 1**, the drilling fluid **120** returns to the wellhead **125** via the annulus **128** and discharges via an inlet port **132** into a fluid/solid separator **130** suitably placed at the sea bottom adjacent the wellhead **125**. The larger/heavier solids **129** are separated by the separator **130** and settle at the bottom section **133** of the separator **130** from where they are discharged or moved into a device **136** (such as a crusher or a pulverizer) which reduces the solids **129** received from the separator **130** into solids of sizes smaller than a predetermined size, which is small enough to be pumped to the surface by a pump **140** via a line **142**. The term crusher is used herein in the generic sense to mean a suitable subsea device that can be used to reduce the size of solids returning with the return drilling fluid. The device **136** preferably is a crusher type or shear type device or any other suitable device, and may be remotely operable from the surface with the use of controller **260** as discussed below. The device **136** is referred herein as a crusher or pulverizer but means any suitable device that can be used for the intended purpose. Alternatively, the solids **129** from the separator **130** may be deposited on the sea floor **126** after reducing their size, as shown by line **141** or without reducing their size. The separator **130** may be a mechanical separator, a centrifuge type or any other suitable separator that is capable of separating solid mass larger than a

predetermined size and/or density from the return fluid.

Relatively small solids remain in the return fluid above the larger solids 129 in the separator 130. The return fluid with the small solids is
5 pumped to the surface by a suitable pump 144 via a fluid line 146. The fluid with small size solids from the separator 130 and the crusher 136 is passed into a solid-water separator 160 at the rig platform 162, which may be a vessel, jack-up rig or a semi-submersible rig. The separator 160 may be any suitable separator utilized in the oil and gas industry and
10 may include a mechanical shaker with one or more screens 164 that filter solids from the fluid in the separator 160. The filtered fluid is discharged into the mud tank 168. The fluid 120 in the mud tank 168 is treated with appropriate additives to obtain the required type of mud and is pumped back into the drill string 112 via line 172. Solids recovered by the surface
15 separator 160 are disposed appropriately.

The subsea separator 130 controls the maximum particle size and/or density of the solids entering into the subsea pump 144. This may be achieved by appropriately selecting the separator 130. In the
20 separator 130 of Figure 1, the separator body has a conical lower section 131 to collect the larger/heavier solids due to gravity and may include one or more screens in the separator 130, such as screen 135,

to prevent passage of solid particle sizes that can damage the subsea pump **144**. For the purpose of this invention, any separator or method may be utilized to prevent passage of large particle sizes from entering the pump **144**. **Figure 1** shows a novel crusher according to one
5 embodiment of the present invention. Thus, the system shown in **Figure 1** resizes larger solid particles from the return fluid and either pumps the reduced sized particles to the surface or discharges them at the sea floor. A separate pump is used to pump the filtered drilling fluid at the sea floor and for pumping the crushed solids to the surface. This system
10 ensures that only solids smaller than the pump specification size pass through the pumps.

Figure 2 shows a solid-fluid separator **200** with an integrated pulverizer. The separator **200** includes a separator section **230** which is
15 substantially similar to the separator **130** of **Figure 1**, but also includes a pulverizer section **240** at the bottom of the conical section **231**. The pulverizer section **240** includes a plurality of cooperating crushers **210a-210b** at the bottom of the conical section **231** of the separator **200**. The solid mass **229** drops or passes to the crushers **210a - 210b**, which
20 reduce such solids to particle sizes below a predetermined size. The discharge **243** from the crusher section **240** which includes drilling fluid mixed with small solid particles is disposed in the manner described

above with reference to **Figure 1**. The discharge **243** from the integrated separator and pulverizer **200** or the separate crusher **136**, shown in **Figure 1**, may be pumped by the pump **140** (see **Figure 1**). The wellstream from the separator **230** and the discharge **243** from the pulverizer **240** may also be pumped to the surface **162** by a common pump **280**, as shown in **Figure 3**. In another aspect of the present invention, as illustrated in **Figure 4**, the solid mass **129** from the separator **130** of **Figure 1** may be discharged into a transportable solid mass storage unit **300** via line **302**. The solid mass **129** from the separator **130** is moved into the storage unit **300** by a suitable mass-moving device **304** such as a screw-type device or a conveyor. Once the solid mass storage unit **300** is full, it is disconnected from the line **302** and transported to the surface. A replacement mass storage unit is then attached to collect solids from continued drilling operation. Alternatively, the solid mass **129** may be collected in removable liners **306** in the storage unit **304**, which liners are retrieved and brought to the surface via a suitable line **308**.

Figure 5 shows an alternative system **330** of transporting solid mass **129** collected in the storage unit **300** of **Figure 4**. In this system, the filtered drilling fluids from separator **230** is pumped into the solid mass storage unit **300** to hydraulically lift and transport the solids **129** to

the surface via a line 335. In this system, the same single pump 340 may be used to transport the filtered fluid by the separator 230 and the separated, but uncrushed, solids to the surface. This system does not require the use of a subsea crusher and also enables the pump to pump
5 only the filtered drilling fluid. Furthermore, the same pump may be used to transport both the drilling fluid and the solids of all sizes and density to the surface.

Figure 6 shows a schematic diagram of an alternative embodiment for subsea processing of drilling fluid with solids 310
10 returning from the subsea wellbore. The fluid 310 from the wellhead 301 first passes via a line 302 into a crusher or pulverizer 312, wherein the larger solids are reduced to small sizes. The fluid with small solid particles 311 passes to a subsea pump system 320 which may include one or more stages in series. The pump system 320 is shown to include
15 three successive stages 322, 324 and 326. The pump system 320 pumps the drilling fluid 311 either to the surface or to a second pump system (not shown). The number of pump stages and the pump systems utilized depends upon the differential pressure that must be overcome to move the fluid 311 to the surface.

20

Figure 7 shows a schematic diagram of a return fluid processing system 350 that contains an integrated crusher and pump system. The

drilling fluid containing all solids 310 passes into a suction chamber 362 that shears the large/heavier solids into small solids. The small solids along with the fluid pass into a pump unit 370 that may include one or more stages. The pump unit 370 is shown to include three stages, each such stage pumping the fluid to the next stage. The fluid with solids from the last stage 376 is pumped to the surface or to another pump unit (not shown). The system of Figures 6 and 7 eliminates the separators such as shown in Figures 1-5.

10 Referring back to Figure 1, the system 100 of the present invention includes a controller or control unit 260 at the surface which controls the operation of various devices in the system 100. The system also includes a plurality of sensors which provide measures of certain parameters of interest of the system 100. Pressure sensors, level
15 sensors, flow rate sensors or any other desired sensors may be provided in the separator 130. Such sensors are generally denoted by numeral 252. Sensors such as pressure sensors, flow rate sensors, etc. may also be provided in various fluid lines in the system 100. Such sensors are generally denoted by numeral 265. The sensor measurements are
20 provided to the controller 260 which computes the values of the appropriate parameter of interest and controls the operation of one or more devices in the system 100. The arrows 257 leaving the sensors

indicate that sensor signals are transmitted to the controller 260 while arrows 258 entering devices 290 indicate that the controller 260 provides signals to such devices to control their operation. The controller 260, for example, may control valves 270, 271, etc. in fluid lines to control the fluid flow into and/or out of the separator 230. The controller 260 may also control the speed of each of the pumps 140, 144, 280, 340 in the system 100 and the operation of the pulverizer 240 and 136.

Thus, the present invention provides a system 100 to control the particle size and methods of disposition of the solid mass in the wellstream at or adjacent the seabed, wherein a controller at the surface may control the operation of the various devices in the system in response to measurements made by one or more sensors relating to one or more parameters of interest of the system 100.

15

While the foregoing disclosure is directed to the preferred embodiments of the invention, various modifications will be apparent to those skilled in the art. It is intended that all variations within the scope and spirit of the appended claims be embraced by the foregoing disclosure.

20

WHAT IS CLAIMED:

- 1 1. An apparatus for processing drilling fluid including solids therein
2 (the return fluid) received at a subsea wellhead during drilling of a
3 subsea wellbore, comprising:
 - 4 (a) a subsea separator receiving said return fluid from the
5 wellbore and separating at least solids from the drilling
6 fluid; and
 - 7 (b) a subsea device associated with said separator reducing
8 size of the separated solids below a predetermined size.
- 1 2. The apparatus according to claim 1 further comprising a first
2 subsea pump for pumping fluid from the separator to a surface location
3 and a second subsea pump for pumping solids reduced by the device.
- 1 3. The apparatus according to claim 1 further comprising a common
2 pump for pumping the drilling fluid from the separator and the solids
3 reduced by said subsea device to a surface location.
- 1 4. The apparatus according to claim 3, wherein the separator
2 includes a selectively operable valve for discharging the separated solids
3 to said pump.

1 5. The apparatus according to claim 2 further comprising a separator
2 at the surface for separating solids from fluid pumped to the surface.

1 6. The apparatus according to claim 1, wherein the subsea device
2 reduces the size of the separated solids to a size that can be pumped to
3 the surface by a subsea pump.

1 7. The apparatus according to claim 1, wherein the subsea device
2 includes a plurality of cooperating crushing members to reduce size of
3 the separated solids.

1 8. The apparatus according to claim 1, wherein the subsea device is
2 one of (i) mechanically-operated; (ii) electro-mechanical; (iii)
3 hydraulically-operated; and (iv) pneumatically-operated.

1 9. The apparatus according to claim 1, wherein the separator
2 comprises:

- 3 (i) a vessel having an inlet for receiving the drilling fluid;
- 4 (ii) a conical section for housing separated solids from the
5 drilling fluid, said conical section having a discharge port of
6 sufficient size to discharge the separated solids from the
7 conical section; and

8 (iii) a control valve for opening the discharge port of the conical
9 section to selectively discharge the separated solids from
10 the vessel to the device.

1 10. The apparatus according to claim 4, wherein the subsea device is
2 remotely-operable from the surface.

1 11. The apparatus according to claim 1 further comprising at least one
2 sensor for providing a measure of a parameter of interest relating to said
3 apparatus.

1 12. The apparatus according to claim 11, wherein the at least one
2 sensor is selected from a group of sensors consisting of a: (i) level
3 sensor; (ii) pressure sensor; and (iii) flow rate sensor.

1 13. The apparatus according to claim 12 further comprising a
2 controller for controlling the operation of the apparatus in response to the
3 measured parameter of interest.

1 14. An apparatus for processing drilling fluid including solids therein
2 received at a subsea wellhead during drilling of a subsea wellbore,
3 comprising:

- 4 (a) a subsea separator separating solids from said drilling fluid
5 into a container; and
6 (b) a pump for pumping the drilling fluid from the separator to
7 the container to move the solids from the container to a
8 surface location.

1 15. A method for processing drilling fluid and solid mixture received at
2 a subsea wellhead during drilling of a subsea wellbore, comprising:

- 3 (a) separating the solids and drilling fluid from the mixture and
4 discharging said separated solids into a container; and
5 (b) transporting the separated solids to a surface location.

1 16. The method of claim 15, wherein transporting the separated solids
2 comprises transporting the container to the surface location.

1 17. The method of claim 15, wherein transporting the separated solids
2 comprises pumping the separated drilling fluid into the container to move
3 the separated solids to the surface location via a suitable conduit.

1 18. An apparatus for processing a mixture of drilling fluid and solids
2 received at a subsea wellhead during drilling of a wellbore, comprising:

- 3 (a) a device receiving the mixture and reducing the size of the
4 solids; and

5 (b) at least one pump receiving the drilling fluid and the
6 reduced sized solids and pumping said received drilling
7 fluid with the reduced sized solids to a surface location.

1 19. The apparatus according to claim 18, wherein the at least one
2 pump includes a plurality of pumping stages.

1 20. A method of processing mixture of drilling fluid and solids received
2 at a subsea wellhead during drilling a subsea wellbore, comprising:

3 (a) separating solids of sizes greater than a first predetermined
4 size from said mixture; and

5 (b) transporting said separated solids to a surface location.

1 21. The method of claim 20 further comprising reducing size of the
2 separated solids to a size smaller than a second predetermined size by a
3 subsea crusher before transporting said solids to the surface location.

1 22. The method according to claim 21, wherein transporting solids
2 comprises pumping said reduced solids to a surface location of a subsea
3 pump.

1 23. The method according to claim 21 further comprising pumping the

- 2 reduced size solids and the drilling fluid to a surface location by a
- 3 common subsea pump.

1/4

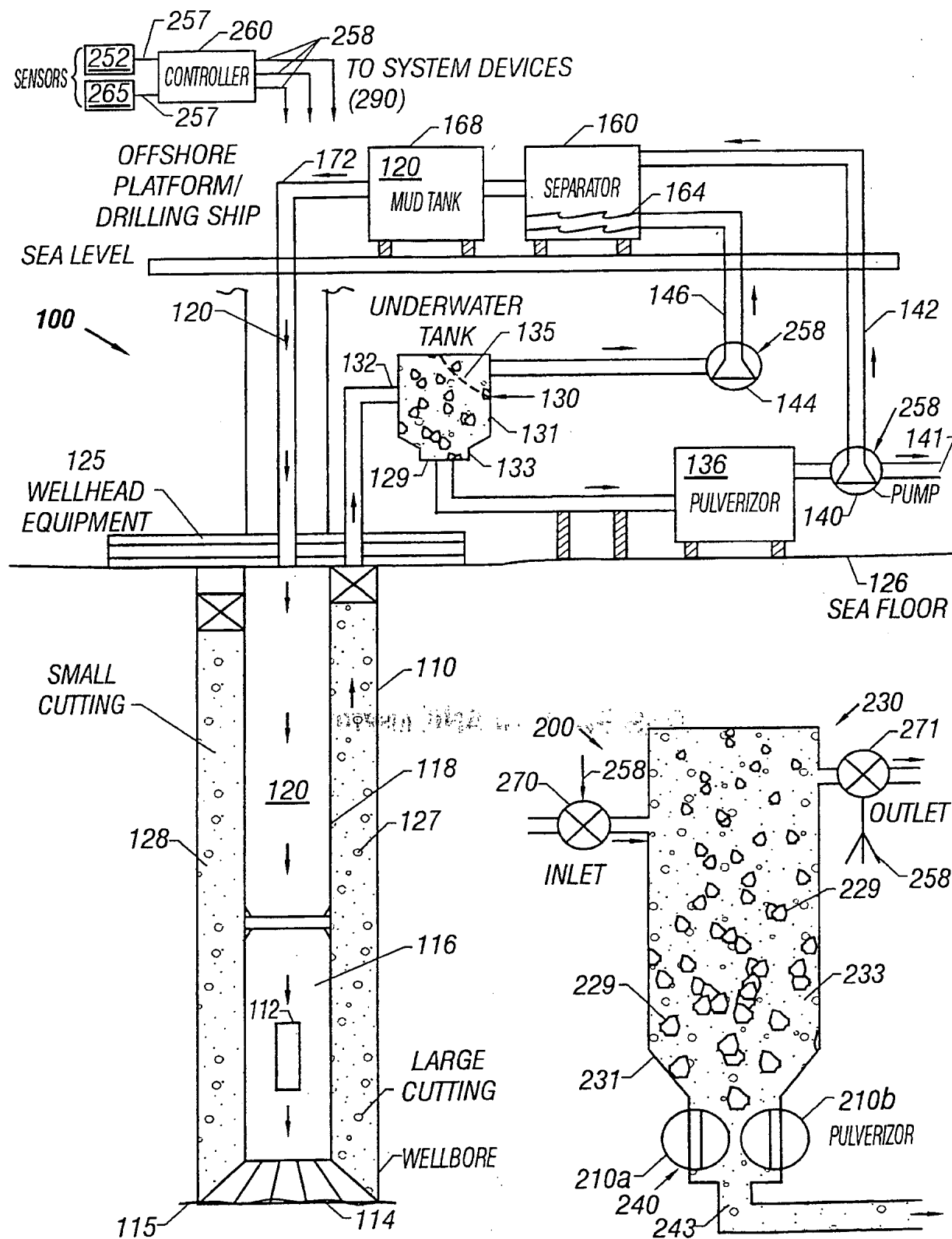


FIG. 1

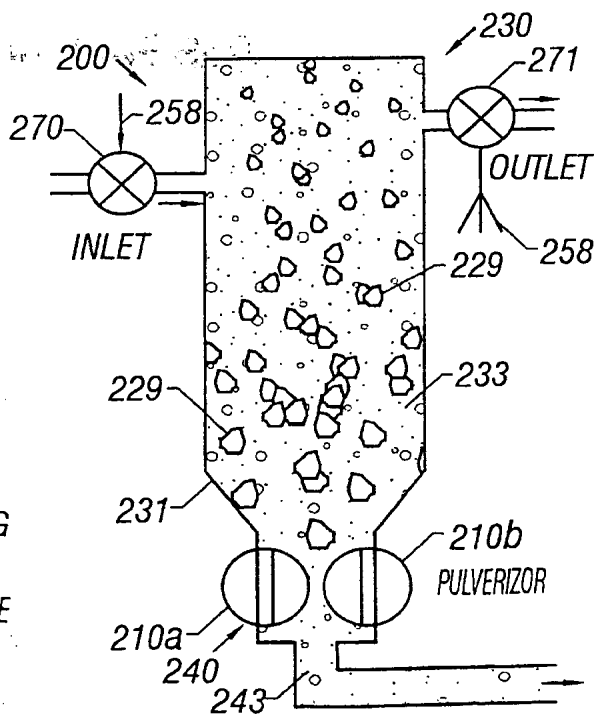


FIG. 2

THIS PAGE BLANK (USPTO)

2/4

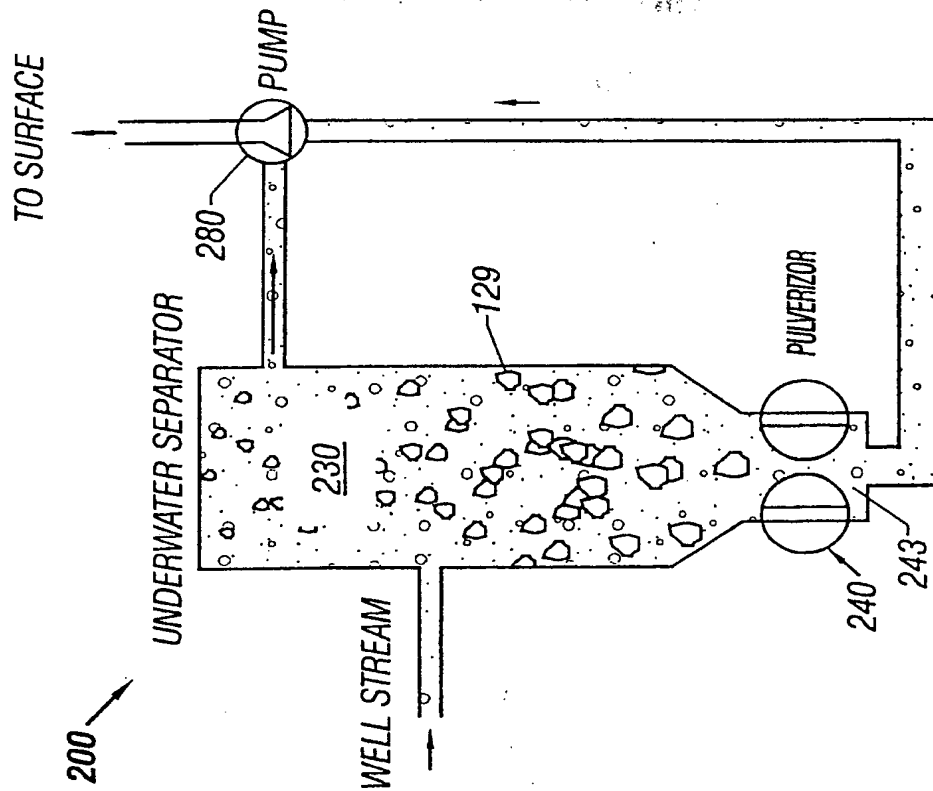


FIG. 3

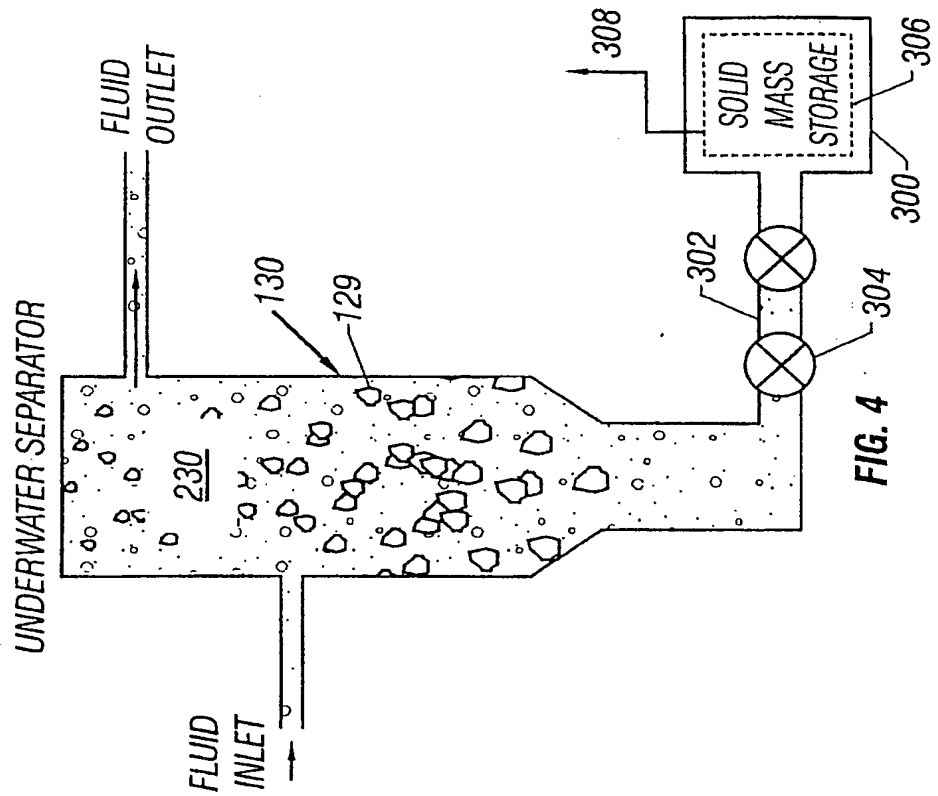


FIG. 4

THIS PAGE BLANK (USPTO)

3/4

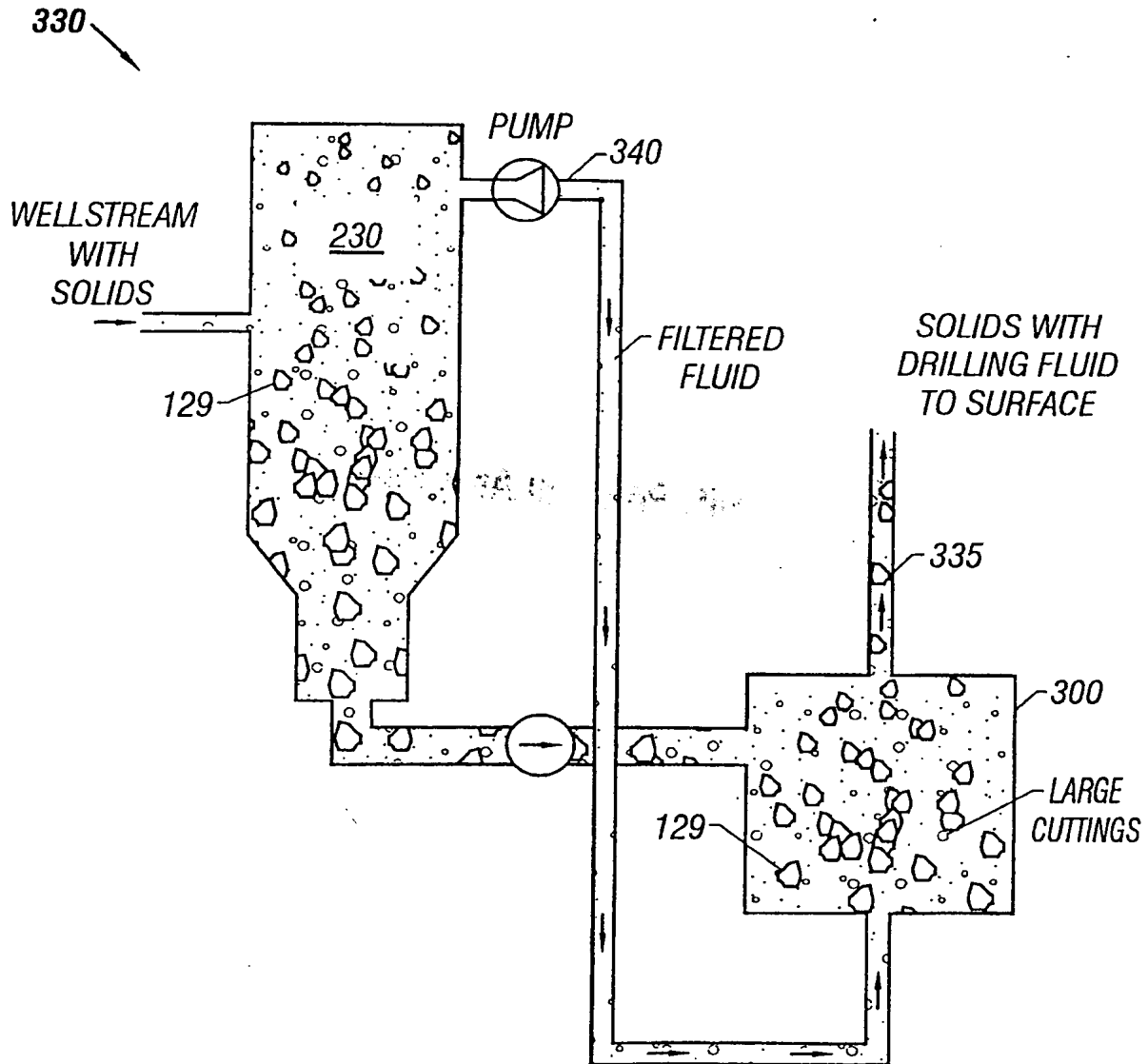


FIG. 5

THIS PAGE BLANK (USPTO

4/4

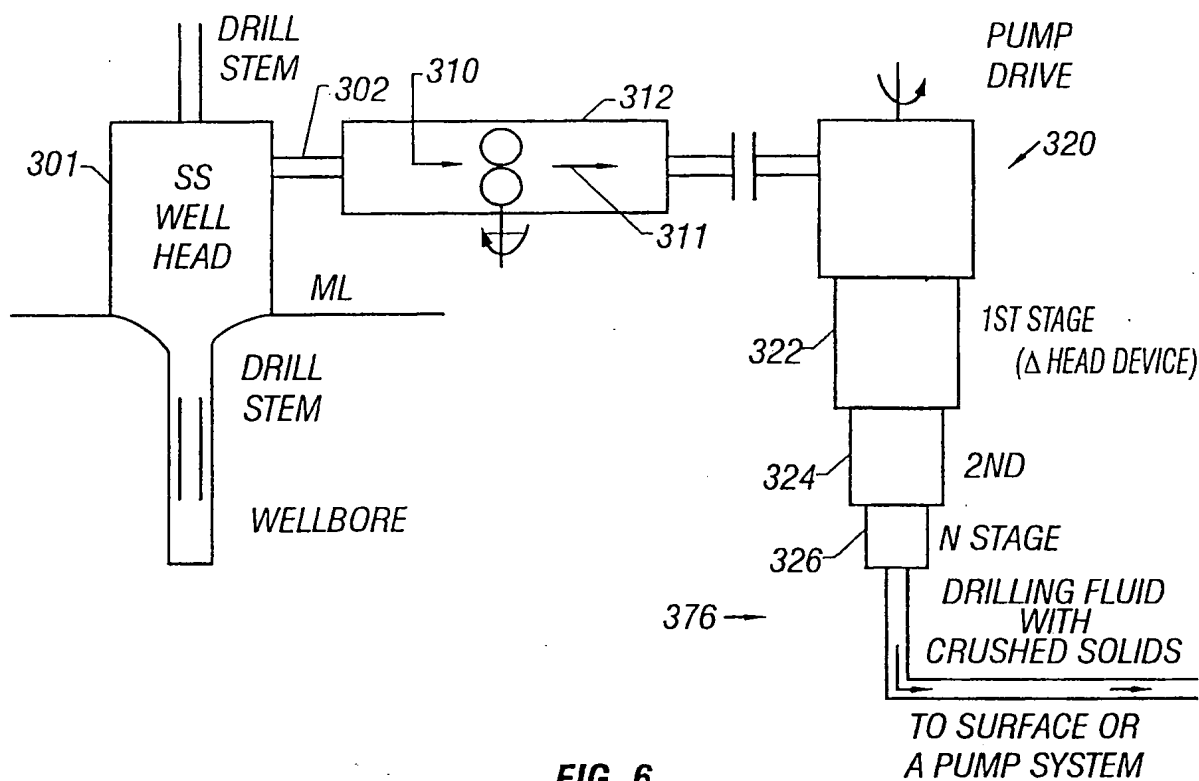


FIG. 6

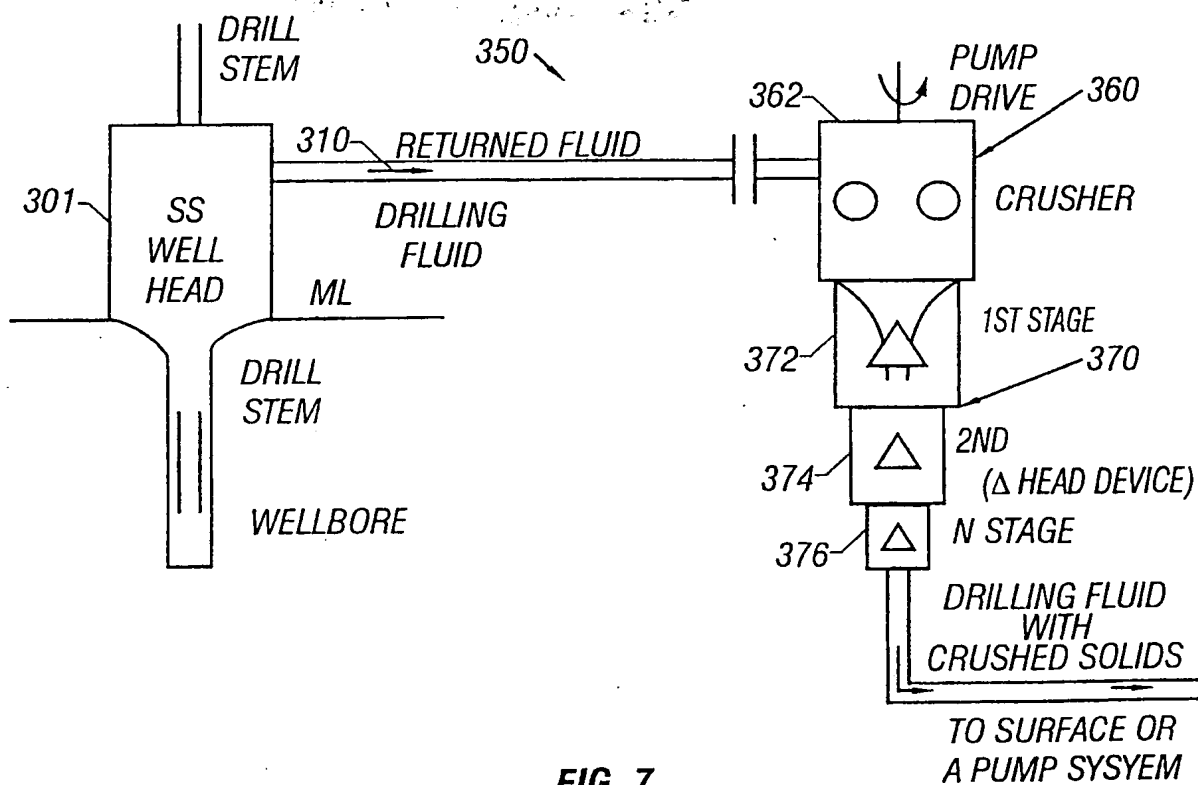


FIG. 7

THIS PAGE BLANK (USPTC

INTERNATIONAL SEARCH REPORT

International Application No.
PCT/US 00/25252

A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 E21B21/00 E21B21/06

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 E21B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	WO 99 15758 A (SHELL INT RESEARCH) 1 April 1999 (1999-04-01) page 2, line 8-11 page 4, line 1 -page 6, line 32 abstract; figures 1,2	14, 15, 20-22
Y	---	1, 4-10, 17, 18
Y	WO 89 09091 A (MELLGREN STEINAR E) 5 October 1989 (1989-10-05) page 5, last paragraph -page 6, paragraph 4; claims 1,2	1, 4-10, 17, 18
Y	US 5 361 998 A (SIREVAG GUNNAR ET AL) 8 November 1994 (1994-11-08) column 1, line 27 - line 42 column 2, line 13 - line 39 abstract	1, 4-8, 10, 17, 18
	--- -/-	

☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

* Special categories of cited documents :

- *A* document defining the general state of the art which is not considered to be of particular relevance
- *E* earlier document but published on or after the international filing date
- *L* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- *O* document referring to an oral disclosure, use, exhibition or other means
- *P* document published prior to the international filing date but later than the priority date claimed

- *T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
- *X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
- *Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.
- *&* document member of the same patent family

Date of the actual completion of the international search

22 December 2000

Date of mailing of the international search report

05/01/2001

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax: (+31-70) 340-3016

Authorized officer

Tompouloglou, C

INTERNATIONAL SEARCH REPORT

Inter. v. Application No
PCT/US 00/25252

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 5 405 223 A (SIREVAG GUNNAR) 11 April 1995 (1995-04-11) abstract	1-23
P,X	WO 99 49172 A (HYDRIL CO) 30 September 1999 (1999-09-30) page 43, line 23 -page 44, line 24; figure 14	1,4,6,8, 10,14, 15,17, 18,20-23

INTERNATIONAL SEARCH REPORT

Information on patent family members

Inter-Application No

PCT/US 00/25252

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
WO 9915758 A	01-04-1999	BR 9812675 A GB 2345506 A NO 20001558 A	22-08-2000 12-07-2000 24-05-2000
WO 8909091 A	05-10-1989	NO 881322 A AU 3291689 A NO 891197 A, B,	26-09-1989 16-10-1989 26-09-1989
US 5361998 A	08-11-1994	NO 905157 A AU 9035591 A CA 2097197 A GB 2266550 A, B WO 9209379 A	29-05-1992 25-06-1992 29-05-1992 03-11-1993 11-06-1992
US 5405223 A	11-04-1995	NO 175412 B AU 9036291 A CA 2097198 A GB 2267301 A, B WO 9209380 A	04-07-1994 25-06-1992 29-05-1992 01-12-1993 11-06-1992
WO 9949172 A	30-09-1999	AU 3105599 A AU 3366499 A AU 3366599 A WO 9950524 A WO 9949173 A US 6102673 A	18-10-1999 18-10-1999 18-10-1999 07-10-1999 30-09-1999 15-08-2000

THIS PAGE BLANK (USPTO)